



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4680-041-BENT
Job Sheet 176960



Part No: D4680-041-BENT

Job Qty: 5 ea

Part Name: Extrusion Bent



Part Weight: 0 lbs

Status: Scheduled

Priority: AOG

Job Created: 5/3/18

Job Tracking No:

Due Date: 5/11/18

Created By: Michelle Gagnon-Donovan

Type: AOG

Description:

Note: DWG REV F IPP REV:A 16.05.16 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	5/11/18	5/11/18	0.00	0.00	Start Up Skid tubes-3		mbh
110	CNC Bend Skid tubes	5 pcs	5/11/18	5/11/18	0.00	1.39	CNC Bend Skid tube		mbh
120	QC	5 pcs	5/11/18	5/11/18	0.00	0.00	QC5		DE
130	Packaging	5 pcs	5/11/18	5/11/18	0.00	0.00	Packaging3-2		mbh
140	QC21-SA	5 Ea	5/11/18	5/11/18	0.00	0.00	QC21		mbh

Part Op 110 - 1- Bend as per dwg D4680 using bend program D4680 and Folio: 26 ***Verify measurement before cutting. 3-29 Cut
Descriptions: FWD end as per dwg D4680

21 MAY 15 2018
9-80

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2962-150 D2962-190	3.540 Outer Tube, Extrud	5 Ea (1 ea)	90-Start up Operation	B100 121

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2962-150	5	0	0

Part Specifications

Specifications could not be found.

Plex 5/3/18 2:25 PM Dart.Gagnon.Michelle



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S071475



Part: D4680 - 041 - BENT

Job No: 176960

Serial No/Batch: S071475

Revision: F

Inspector:

Date: 05/15/18

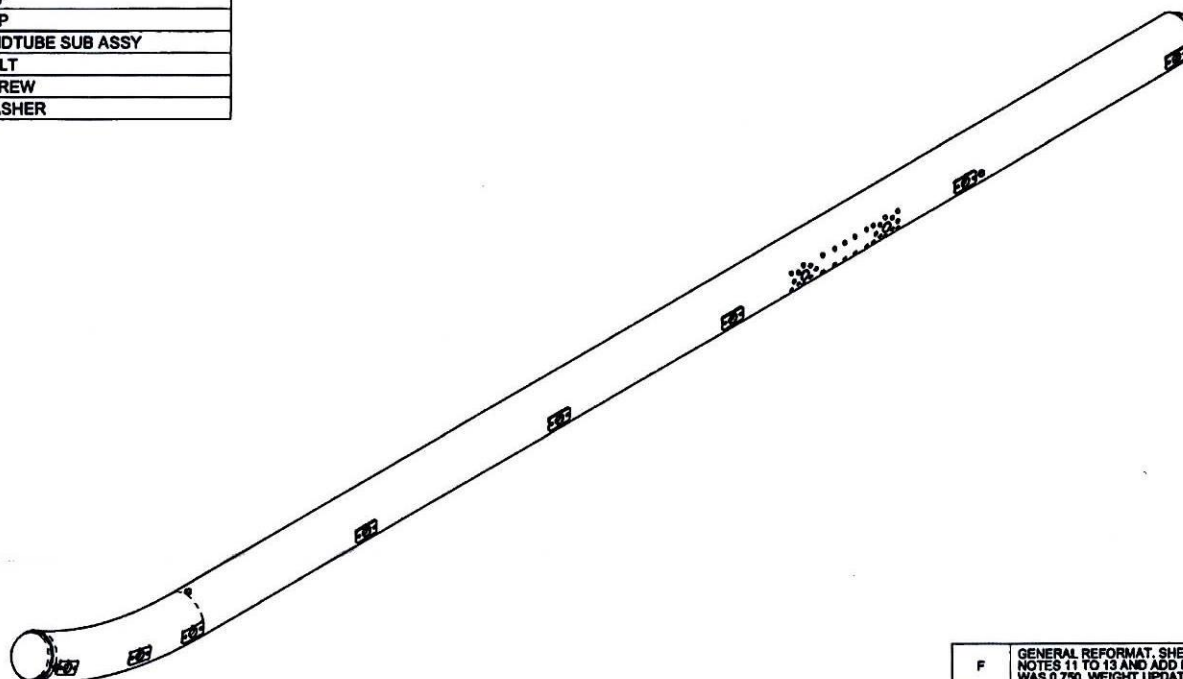
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WITHOUT NOTICE
WORK ORDER

NO. 176960

MAY 03 2018

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4680-041	SKIDTUBE
1	1	D2965	CAP
2	1	D2965-3	CAP
3	1	D4680-043	SKIDTUBE SUB ASSY
4	2	AN3C5A	BOLT
5	2	AN526C1032R10	SCREW
6	2	NAS1149C0332R	WASHER



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 1.00 ABOVE CENTERLINE PER QSI 005 SECTION 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4680-041" AND B/N PER QSI 044 METHOD 6.4 ON INNER RADIUS OF SKIDTUBE BEFORE INSTALLING D2965 CAP

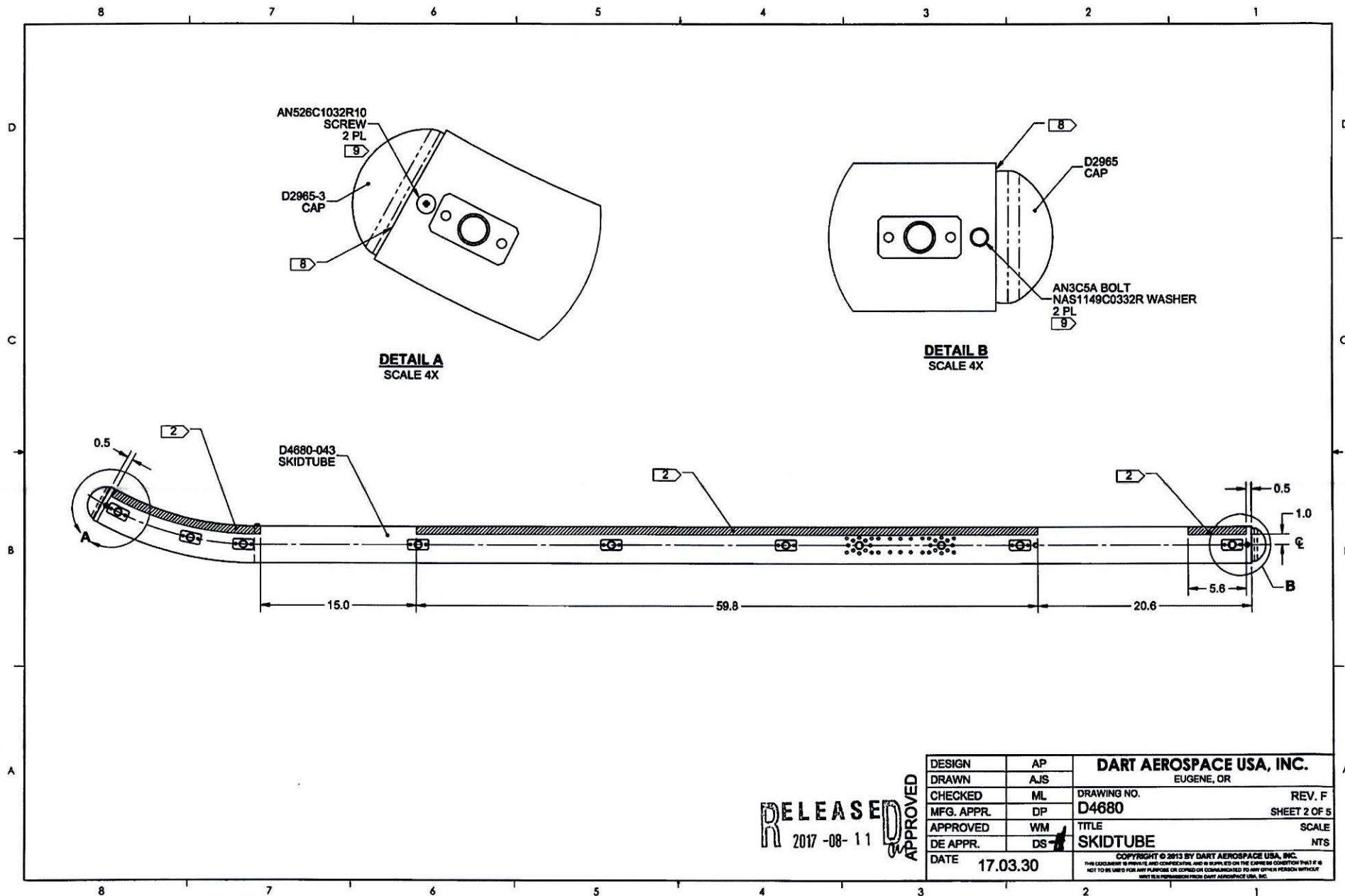
- 7) WEIGHT: 19.3 lbs
- 8) SEAL FAYING SURFACES WITH SIKAFLEX -241/-291 OR PROSEAL 890/1422 OR MIL-S-8802 CLASS B-2 SEALANT
- 9) INSTALL FASTENERS WET WITH SIKAFLEX -241/-291 OR PROSEAL 890/1422 OR MIL-S-8802 CLASS B-2 SEALANT

RELEASED
2017-08-11
EN17-547

F	GENERAL REFORMAT. SHEET 3: ADD ITEMS 8 & 11 ADD NOTES 11 TO 13 AND ADD DETAIL H. SHEET 5: Ø0.188 WAS 0.750. WEIGHT UPDATE. ADD PROSEAL 1422	AJS	17.03.30
E	GROUND HANDLING CROSSBOLT SPACERS NOW SWAGED. WAS WELDED. REMOVED D3492-055 PLUG ASSEMBLIES	AP	15.11.02
D	MOVED AFT GROUNDING FASTENER HOLE AFT 0.25 DUE TO INTERFERENCE. ADDED NOTE 9 (SHT 1), GROUNDING STRAP WASHERS NOW STAINLESS	AP	15.03.04
C	NAS1149F0332P WAS AN980-10L. AN526C1032R10 WAS AN526C1032-10. FWD GROUNDING STRAP FASTENER MOVED AFT (C5-3), Ø0.750 WAS Ø0.758 (B4-3).	AP	14.07.29
B	FWD CAP WAS D2965. NOW D2965-3. VARIOUS DIMENSIONAL CHANGES. D3492-055 PLUG ASSY WAS D3492-051. SWAGING DIMENSION NOW 0.650 WAS 0.661 (D6-2). ADDED DETAIL H (C2-3). MATERIAL D2962-150 WAS D2962-131 (A7-3). GROUND HANDLING THRU HOLES NOW WELDED. ADDED SECTION 6-3 (D3-2)	AP	13.09.10
A	NEW ISSUE	AP	13.02.13
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	AJS	DRAWING NO.	REV. F
CHECKED	ML	D4680	SHEET 1 OF 6
MFG. APPR.	DP	TITLE	SCALE
APPROVED	WM	SKIDTUBE	NTS
DE APPR.	DSS	DATE 17.03.30	

APPROVED

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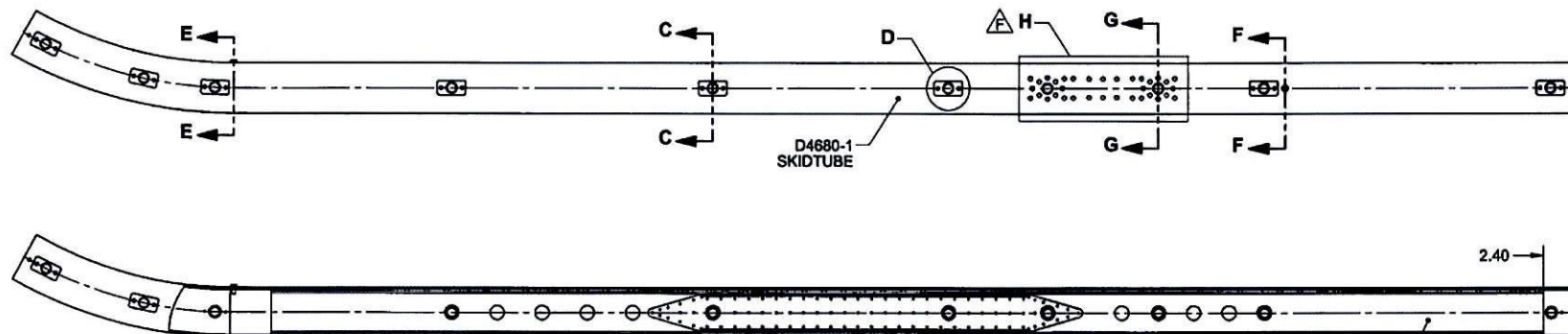
ITEM	QTY -043	P/N	DESCRIPTION
	X	D4680-043	SKIDTUBE SUB ASSY
1	1	D4680-1	SKIDTUBE
2	1	D4681-041	WEB ASSY
3	8	D4686-1	SPACER
4	16	D4753-1	DOUBLER
5	2	D5304-1	CROSSBOLT SPACER
6	2	D5520-1	DOUBLER
7	3	AN3C4A	BOLT
8	32	MS20801AD4W3	RIVET, BLIND, CSK
9	3	NAS1149C0332R	WASHER
10	3	AELS-1032-130	INSERT
11	68	CR3212-5-05	CSK RIVET, CHERRY MAX

OPEN TO
Ø0.750
THRU 2 PL

13 12 CR3212-5-05
CSK RIVET, CHERRY MAX
34 PL PER DOUBLER

DETAIL H
SCALE 4X

11 D5520-1 DOUBLER
2 PL



D4680-043 SKIDTUBE SUB ASSY

9 D4681-041
WEB ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: APPLY CHEMICAL CONVERSION COATING PER DART QSI 005 4.1 PRIOR TO INSTALLING D4681-041 WEB. POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 18.6 lbs
- 8) SEAL ALL MATING SURFACES USING PROSEAL 890/1422 OR MIL-S-8802 CLASS B2 SEALANT
- 9) INSERT D4681-041 WEB INTO D4680-1 SKIDTUBE IN LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX -241/-291 ADHESIVE PER DART QSI 015
- 10) INSTALL D4686-1 SPACER AFTER INSTALLING D4753-1 DOUBLERS
- 11) LOCATE THE D5520-1 DOUBLER USING THE Ø0.188 PILOT HOLES ON THE SKIDTUBE AND DOUBLER
- 12) LOCATE QTY (34) HOLES ONTO THE SKIDTUBE PER D5520-1 DOUBLER AND DRILL Ø0.161 THRU SKIDTUBE AND DOUBLER USING DT10309
- 13) COUNTERSINK THE SKIDTUBE Ø0.286 X 100° (34 PL) AND INSTALL EACH D5520-1 DOUBLER USING QTY (34) CR3212-5-05 CSK RIVETS

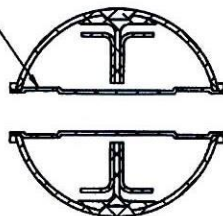
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2017-08-11

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DESIGN	AP	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	AJS		
CHECKED	ML	DRAWING NO. D4680	REV. F
MFG. APPR.	DP	SHEET 3 OF 5	
APPROVED	WM	TITLE SKIDTUBE	SCALE NTS
DE APPR.	DS	DATE 17.03.30	

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D4686-1
SPACER

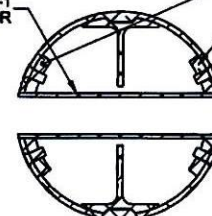


10 SECTION C-C
SCALE 4X
8 PL

INSTALL D4686-1 SPACER AS FOLLOWS (8 PL)
AFTER INSTALLING D4753-1 DOUBLERS PER DETAIL D

1. INSERT D4686-1 SPACER
2. SWAGE TO $\phi 0.650 +0.010/-0.000 \times 1.0$
DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

D5304-1
CROSSBOLT SPACER



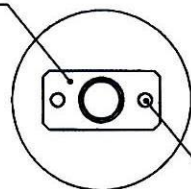
SECTION G-G
SCALE 4X
2 PL

D5520-1 DOUBLER
REF

INSTALL D5304-1 SPACER AS FOLLOWS (2 PL)

1. INSERT D5304-1 SPACER
2. SWAGE TO $\phi 0.585 +0.005/-0.000 \times 1.0$
DEEP PER QSI 002
3. OPEN THRU HOLE TO $\phi 0.625$

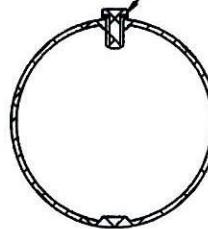
8
D4753-1
DOUBLER



DETAIL D
16 PL (BOTH SIDES)
SCALE 4X

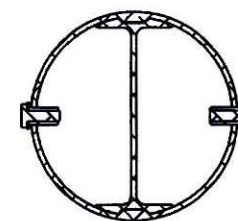
MS20601AD4W3
RIVET, BLIND, CSK
2 PL

AN3C4A BOLT
NAS1149C0332R WASHER
AELS-1032-130 INSERT



SECTION E-E
SCALE 4X

AN3C4A BOLT
NAS1149C0332R WASHER
AELS-1032-130 INSERT
2 PL



SECTION F-F
SCALE 4X

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2017-08-11

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DESIGN	AP	DART AEROSPACE USA, INC.	
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CHECKED	ML	DRAWING NO.	REV. F
MFG. APPR.	DP	D4680	SHEET 4 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	SKIDTUBE	NTS
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